

Work Order ID 78224-3

January-02-12 3:51:04 PM

78224

Page 1

Item ID: D3937-041

Revision ID:

Item Name: Luminescent Strip Assembly

Start Date: 02/01/2012 Start Qty: 64.00

Required Date: 16/01/2012 Req'd Qty: 64.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

64

64

Approvals: Process Plan: M.L.S

QC:

Date: 12/01/02 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3937

B

100

0.00

100

Shear

Shear

Memo

0.00

1-Cut as per Dwg D3937 (Make D3937-3)
Dwg Rev: B

2-Deburr if necessary

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

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Item ID: D3937-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Luminescent Strip Assembly

Stop

NS2

Start Date: 02/01/2012 Start Qty: 64.00

64

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 64.00

64

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

66 BL 12-1-25

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

66 d 12/01/12

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Align part edges and stick strip to D3937-3 as per dwg

17

FF
12/04/12

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Item ID: D3937-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Luminescent Strip Assembly

Start Date: 02/01/2012 Start Qty: 64.00

64

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 64.00

64

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/2/12/20

(17)

170

Identify as per dwg & Stock Location: *73*

0.00

170

Packaging

Memo

0.00

Packaging

(17/1)

12/4/23

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/23

12-04-23

Picklist Print

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Work Order ID: 78224

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Parent Item: D3937-041

D3937-041

Parent Item Name: Luminescent Strip Assembly

Start Date: 02/01/2012

Required Date: 16/01/2012

Start Qty: 64.00

Required Qty: 64.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3937-1		Manufactured	No				Each	3.0000		64			
D3937-1									**				
Luminescent Strip													

Location	Loc Qty	Loc Code
ST094	3	
73537	3	

M6061T6S.032

Purchased

No

100

sf

68.8840

0.09099

6.129853

M6061T6S 032

6061-T6 Sheet 0.032"

**

Location	Loc Qty	Loc Code
MAT021	68.884	
118106	68.384	
16954	0.5	

118106
16954

M 123255 - 2

FF 12

12-01-24

FF 12/04/18

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3937-041	LUMINESCENT STRIP ASSEMBLY
2	1	D3937-1	LUMINESCENT STRIP
3	1	D3937-3	SHEET METAL BACKING STRIP

PEEL SELF-ADHESIVE BACKING FROM
D3937-1 LUMINESCENT STRIP,
ALIGN PART EDGES AND STICK TO
D3937-3 SHEET METAL BACKING STRIP

D3937-041 LUMINESCENT STRIP ASSEMBLY

78224 M.C.S.
12/01/02

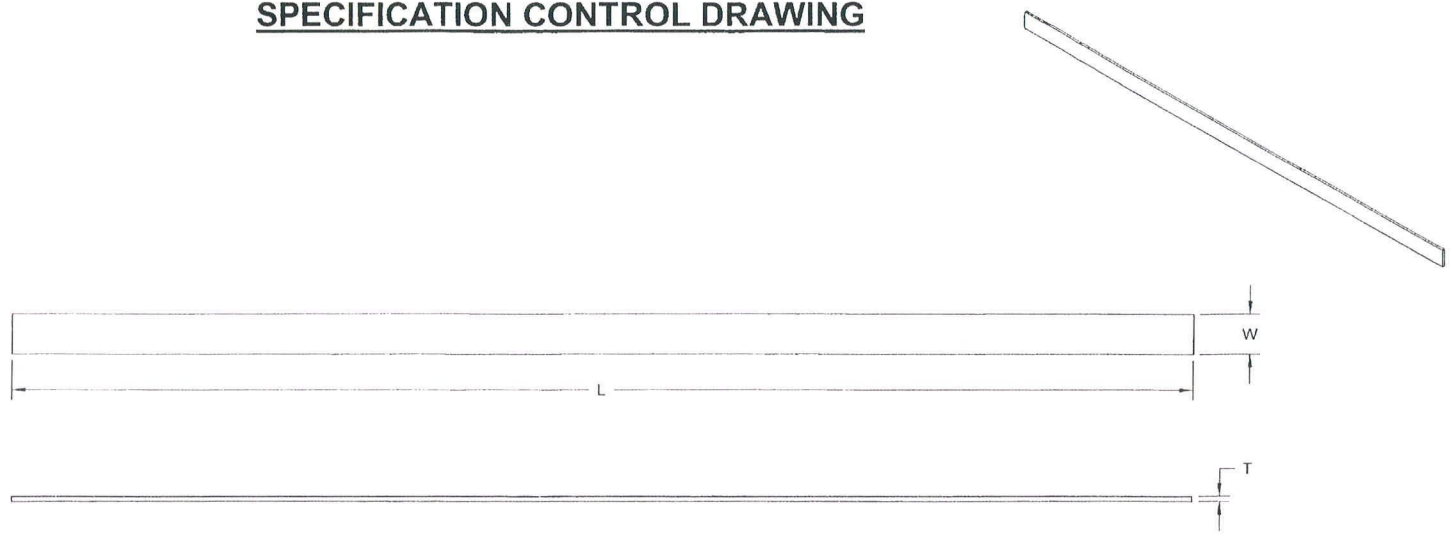
RELEASED
2009-12-02
M.D.

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

B	SHEET 2 SPEC CHART LENGTH WAS 21.0. SHEET 3 ZONE C5 19.5 DIM WAS 21.0 REASON: PREVENT EXCESSIVE WASTE.		AJS	09.11.27
A	NEW ISSUE		BY	DATE
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		DRAWING NO.	REV. B
CHECKED	AJS		D3937	SHEET 1 OF 3
MFG. APPR.	AJS		TITLE	SCALE
APPROVED	AJS		LUMINESCENT STRIP	NTS
DE APPR.	AJS		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PARTY OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.11.27			

78224

SPECIFICATION CONTROL DRAWING



D3937-1 LUMINESCENT STRIP

DART PART NUMBER	LENGTH "L"	WIDTH "W"	THICKNESS "T"	SUPPLIER	SUPPLIER PART NUMBER	WEIGHT
D3937-1	19.5	0.67	0.09	LUFTHANSA TECHNIK	PL88-990LH00	0.04 LBS



RELEASED
2009-12-02

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE TABLE

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3937	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUMINESCENT STRIP	NTS
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